

Work Order ID 59587

Tuesday, June 08, 2010 11:41:36 AM



Page 1

Item ID: D350-748-241TRN

Accept

Revision ID:

Item Name: Crosstube Turning Detail

Start Date: 6/8/2010 Start Qty: 1.00

Required Date: 6/21/2010 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date: 10-6-08 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D350-748-241

Rev E

100



Mori Seiki

Mori Seiki CNC Lathe Large

MORI SEIKI CNC LATHE LARGE

0.00

Memo

0.00

1-Fill tube with sand & install plugs on both ends as per Folio FA647
2-Turn first side as per Folio FA647
3- File transition lines smooth.

Q.M. 10 - 06 - 11 @

110



QC

Quality Control

QC1- Inspect dimensions to dimension sheet

0.00

Memo

0.00

Q.M. 10 - 06 - 11 @

120



Mori Seiki

Mori Seiki CNC Lathe Large

MORI SEIKI CNC LATHE LARGE

0.00

Memo

0.00

1-Turn second side as per Folio FA647
2- File transition lines smooth.
3-Scribe part # as per Dwg D350-748-241

Q.M. 10 - 06 - 11 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Accept



Setup

Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC1- Inspect dimensions to dimension sheet

0.00

QC
Quality Control

Memo

0.00

QA 10-06-11 @

140

QC8- Inspect parts - second check

0.00

QC
Quality Control

Memo

0.00

IX MB 10-06-10

150

Large Fab

0.00

Crosstubes
Crosstubes

Memo

Grind machining marks.

0.00

1 - - AWM 10-06-21

W/O:		WORK ORDER CHANGES					
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Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Outsource process - Heat Treat

0.00



Outsource1

Memo

0.00

Outsource process - Heat Treat

Issue P/O: 12209
Heat Treat to min 180 KSI As per Dwg D350-748-241
Sand Blast tube after Heat Treat
Possible Supplier: Vac Aero
Ensure Certificate of Conformity is attached

CZ 10/7/06 ①

170

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure certificate of conformaty is attached

P 10/7/2 ①

180

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

S10103h3

POSITIVE RECALL

EFFECTIVE 10.10.06 AUTH CPRELEASED CP DATE 10.07.23

★ SEE NGR NOVERA ★

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-748-241 TRN PAR #: _____ Fault Category: X-tubes NCR: Yes No DQA: [Signature] Date: 100805
 Resolution: re-work Disposition: re-work QA: N/C Closed: [Signature] Date: 10/03/06

NCR: <u>59587</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.07.06	15 D	MARK IN RAW MAT'L. IN CENTER UNMACHINED AREA. R.C. process.	<u>CP</u> 10.07.06 CS/042	Tube ground 0.010" to RMV mark. @ ~ 53-58" FROM CUFF w/ D-PART ENGRAVING. NOTE LOCATION FOR BENDING	<u>CP</u> 10.07.06	<u>S</u> 10/07/06	<u>CP</u> 10.07.06 CS/042	<u>S</u> 10/03/06

NOTE: Date & initial all entries

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Page 4

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Reference:

Accept



Setup

Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190



Packaging

Packaging

Memo

Identify and stock in kanban rack
Location: 416

0.00

0.00

DP 10-8-5

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/08/05

MLF
10-08-05

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 08, 2010 11:41:41 AM

Page 1

Work Order ID: 59587

Parent Item: D350-748-241TRN

Parent Item Name: Crosstube Turning Detail

Comments: IPP Rev:A New Issue 08-03-06 DD verified by:ec
 IPP Rev B Removed polish 08.04.02 EC verified by : DD
 IPP Rev C Removed LPS-3 08.06.23 Ec verified by: DD

Start Date: 6/8/2010

Required Date: 6/21/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
D6018-125		Manufactured	No			120	Each	50.0000	1	1			
Crosstube Material													

Location

Loc Qty

Loc Code

LG

50

32913

50

AM 10-06-11

1

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	59587
Description: Crosstube Assembly (AS350/355 High Aft)		Part Number:	D350-748-241
Inspection Dwg: D350-748-241 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.245	/			
	2.180	+0.005/-0.000	2.185	/			
	2.180	+0.005/-0.000	2.185	/			
	2.208	+0.005/-0.000	2.213	/			
	2.234	+0.005/-0.000	2.239	/			
	2.253	+0.005/-0.000	2.258	/			
	2.272	+0.005/-0.000	2.277	/			
	2.299	+0.005/-0.000	2.304	/			
	0.063	+/-0.010	0.063	/			
	4.26	+/-0.030	4.260	/			
	R0.063	+/-0.010	R0.063	/			
	R0.50	+/-0.030	R0.500	/			
SIDE B	2.240	+0.005/-0.000	2.245	/			
	2.180	+0.005/-0.000	2.185	/			
	2.180	+0.005/-0.000	2.185	/			
	2.208	+0.005/-0.000	2.213	/			
	2.234	+0.005/-0.000	2.239	/			
	2.253	+0.005/-0.000	2.258	/			
	2.272	+0.005/-0.000	2.277	/			
	2.299	+0.005/-0.000	2.304	/			
	0.063	+/-0.010	0.063	/			
	4.26	+/-0.030	4.260	/			
	R0.063	+/-0.010	R0.063	/			
	R0.50	+/-0.030	R0.500	/			
	122.70	+/-0.060	122.700	/			

Measured by:	Q. N.	Audited by:	MB	Prototype Approval:	N/A
Date:	10-06-11	Date:	10-06-16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue (P/O D350-748-201)	KJ/JLM	

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Item	Qty -241	Part Number	Description
1	X	D350-748-241	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
2	1	D6018-125	CROSSTUBE
3	2	D3502-1	SUPPORT
4	2	D2856-400-710	ABRASION STRIP
5	1	AELS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
8	1	MS27039-1-10	SCREW

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6018-125
FINISHED LENGTH = 122.700±0.06
- 2) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D350-748-241" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 29.85 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø.297 HOLE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING.
- 12) INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 13) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 14) TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHIN 90 DAYS
WORK ORDER
NO. 59587
2810-5-08

RELEASED
R 2009-10-29

E	REVISE GENERAL NOTES; UPDATE TO CURRENT STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A8-3); ADD TOLERANCES (ZN C6-3, D2-3)	RF	09.09.30
D	MAG. PARTICLE AND CAD PLATE AS MFD.	CP	06.10.31
C	ADD CAD PLATING	CP	06.08.14
B	ADD D6018-125 & PRIME AND PAINT	CP	06.06.30
A	NEW ISSUE	CP	06.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. E D350-748-241 SHEET 1 OF 4 TITLE SCALE CROSSTUBE (AS 350/355 HI AFT) NTS	
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF	DATE 09.09.30	
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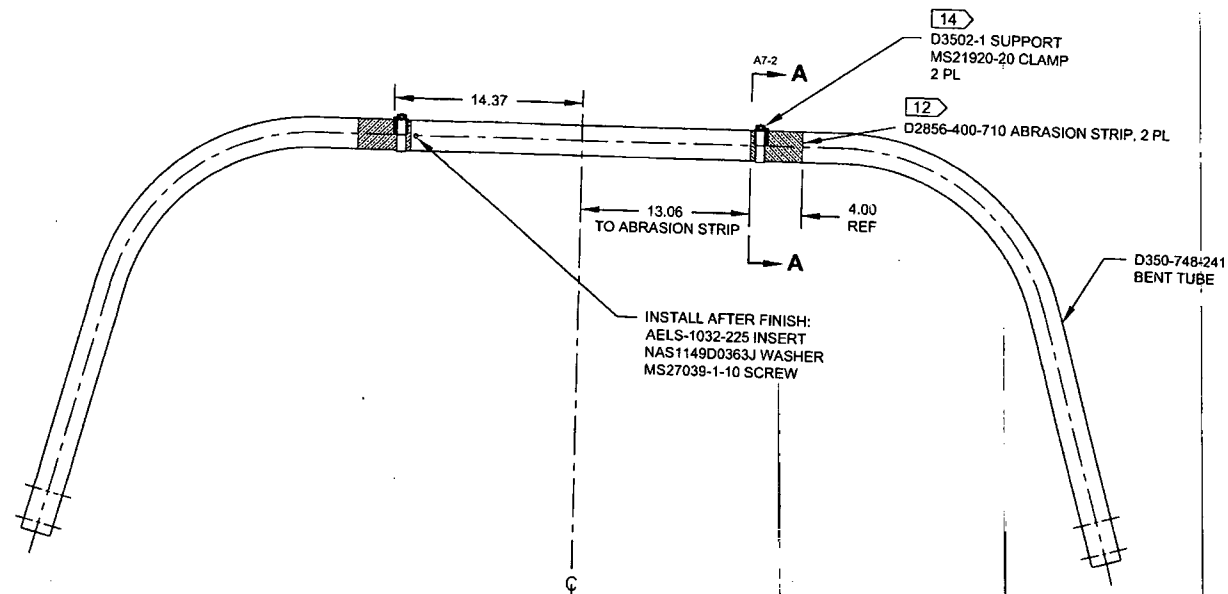
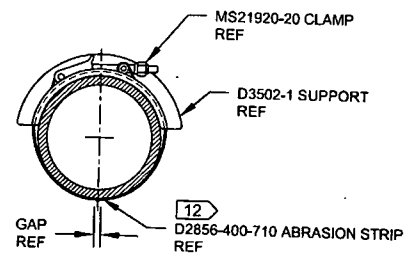
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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**D350-748-241
ASSEMBLY DETAIL**

SECTION A-A
SCALE 4X



DESIGN	Q	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Q	DRAWING NO.	REV. E
MFG. APPR.	Q	D350-748-241	SHEET 2 OF 4
APPROVED	140	TITLE	SCALE
DE APPR.	H	CROSSTUBE (AS 350/355 HI AFT)	NTS
DATE	09.09.30	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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RELEASED
2009-10-29
MD

wlo 59587

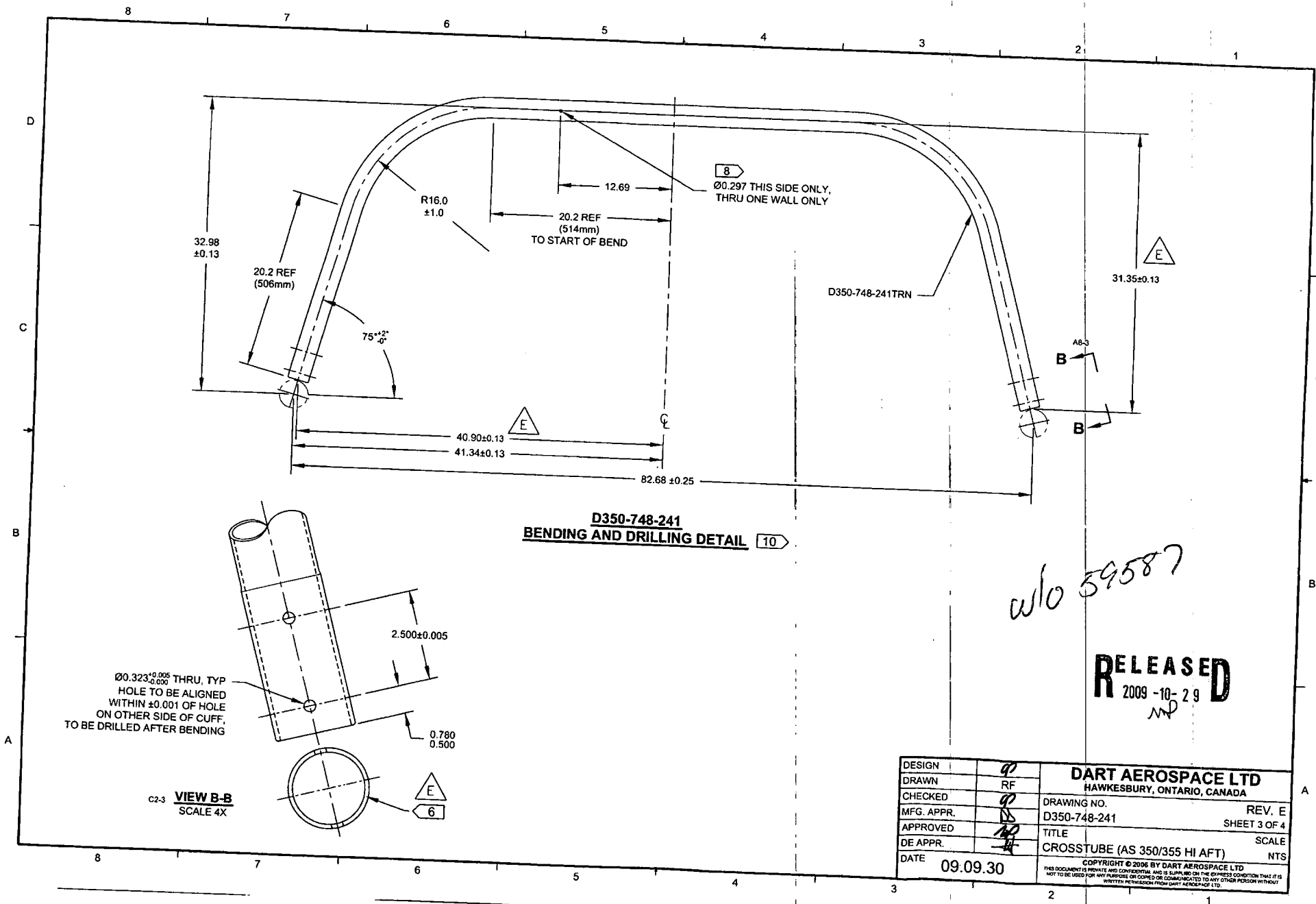
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D350-748-241	SHEET 3 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE (AS 350/355 HI AFT)	NTS
DATE	09.09.30	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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VAC AERO
INTERNATIONAL INC.

RELEASE NOTE

GST No.: R105468102

OAK 121151-1



HEAD OFFICE
1371 SPEERS ROAD, OAKVILLE, ONTARIO
CANADA L6L 2X5
TEL: (905) 827-4171 FAX: (905) 827-7489



2009 WYECROFT ROAD, UNIT B
OAKVILLE, ONTARIO
CANADA L6L 6J4
TEL: (905) 827-7377 FAX: (905) 827-1380



QUEBEC DIVISION
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

07/16/2010

MM / DD / YYYY

PAGE: 1

ILL TO: 1DAR01
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
07/16/2010		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
PO12209		NET 30 DAYS

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
----------	-------------	-----	------------	-------------	--------------

D350-748

CROSS TUBE

EA 16 16

Process Specifications: Procedure: 4353
HEAT TREATED TO 180 KSI MIN. PER AMS 2759-1E
100% HARDNESS TESTED AS PER ASTM E-18, 40-45 HRC
MATERIAL: 4130
SAND BLASTED AFTER HEAT TREAT

8/10/07/25

P/N: D350-748-141: 59325, 59326, 59327, 59328, 59329, 59330, 59331, 59332
P/N: D350-748-241: 59586, 59588, 59589, 59549, 59587, 59550, 59551, 59552

100% HARDNESS TESTED

16 pcs

42/43 HRC



hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant hereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.



METAL TREATING INSTITUTE

Jane Robinson
Authorized Q.C. Inspector



Heat Treating • Welding

VACUUM BRAZING - HEAT TREATING - SPECIAL PROCESSING - FURNACE EQUIPMENT
TURBINE COMPONENT OVERHAUL - PLASMA AND OTHER COATINGS